

Date: Friday, 11/18/2005 1:23:54 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 24772		Part Number	: D31561	
Estimate Number	: 10398		Drawing Number	: D3156 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/18/2005	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/20/2005	
Previous Run	: 24706		Qty:	10	
Written By	: See comment below		Um:	5	
Checked & Approved By	: See comment below		Each		
Comment	: Est A 04.11.30 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M2024T3S050	2024-T3 .050 sheet		
		Comment: Qty.: 0.4739 sf(s)/Unit Total : 2.3693 sf(s) Note: To be made in multiples of 10 Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Batch: M 19053		Ep 05/12/12 10
2.0	SHEAR	SHEAR		
		Comment: SHEAR Cut blank: 1.950" x 0.700" grain along 1.950"		Ep 05/12/12 10
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA477 and Dwg D3156 Stack of 10 Identify as D3156-1		Ep 05/12/12 10
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		Ep 05/12/12 10
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		Ep 05/12/12 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D31561 PAR #: Fault Category: Production/machinery parts NCR: Yes No DQA: Date: 05/12/16
 QA: N/C Closed: Date: 05/12/16

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/12	# 3.0	3 stacks (30 parts) SCRAP. MOVED in clamp	B 05/12/12	SCRAP + destroy and Replace	E 05/12/12	J	B 05/12/12	J

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 05/12/12

10

7.0 BRAKE NC



NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3156

SB 05/12/12

10

8.0 QC5



INSPECT WORK TO CURRENT STEP



J 05.12.13

10

Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



10

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

E 05.12.14

10

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



J 05.12.14

10

Comment: INSPECT CHEMICAL CONVERSION COAT

11.0 PACKAGING 1



PACKAGING RESOURCE #1



SB 05/12/15

10

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: CA - 18

C 05/12/15

10

12.0 DC



DOCUMENT CONTROL



10

Comment: DOCUMENT CONTROL

Inspection Level 21

5/12/16

10

10

05/12/16

10

Job Completion



0000000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024772
Project Name : D3156-1 Department Code:
Project For : WK550 Burden Flags : NNNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D3156-1 Invoice Date :
Description : Bracket Invoice Number :
Manufactured : Yes Invoice Amount : 0.00
Amount Req'd : 5
Amount Done : 0 Order Entry No :
Start Date : 11-17-05 OE Value : 0.00
Est Finish Date : 12-10-05
Act Finish Date : Est Margin : 0.000%
Drawings Reqd : No Actual Margin : 0.000%
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

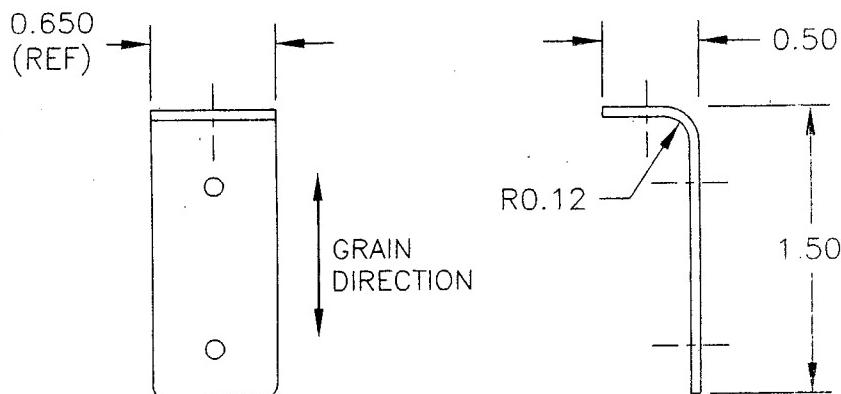
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLED COPY

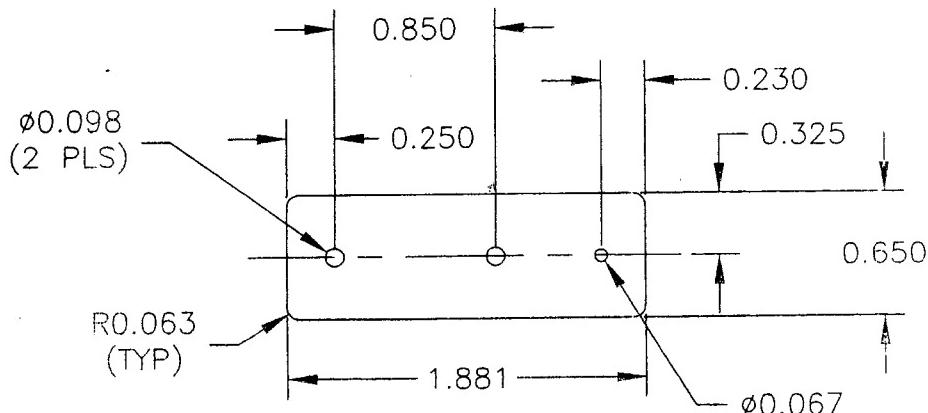


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3156
DATE 04.10.18		REV. B SHEET 1 OF 1 SCALE 1:1
A	02.04.24	NEW ISSUE
B	04.10.18	ADD PART MARKING

RELEASED
04.11.23 - H



D3156-1 BRACKET



D3156-1 BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024-0.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-117
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DART AEROSPACE LTD	Work Order:	24472
Description: BRACKET	Part Number:	D3156-1
Inspection Dwg: D3156 Rev: 3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<i>EN</i>	Audited by:	<i>MB</i>	Prototype Approval:	
Date:	<i>05/12/12</i>	Date:	<i>05/12/12</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	.	New Issue	Kj/RF	